

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006398**Date Inspected:** 21-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1715**Contractor:** Goodwin Steel, UK**Location:** Stoke-on-Trent, UK**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Cable Band**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Randall Riegler was present during the times noted above for observations relative to the work being performed.

Observed welding of a welder qualification coupon.

This coupon was being welded by Adam Migas using SMAW to qualify for the 2G position. The welding was being witnessed by Les Peake, QCM. 4 mm E7018-1 electrodes were being used. Observed amperage was within WPS limitations observed varying between 101 and 110 amps. The procedure, WPS04-0120F4A, allows amperage's between 100 and 180.

Observed Steve Whitehead making weld repairs on Casting B14-CBB G29447-1. He was observed making a vertical weld using a wide weave (in excess of the 15 mm allowed for vertical welds.) This was reported to Lee Davies and Jason Cross. No action has been taken at this time. The welding procedure WPS04-0120F4B, was available at the work area. Photographs are attached.

As previously reported, radiography of castings B15-1-F G29449-1 and B15-1-M G29448-1 is complete. The Radiographic Inspection Reports, and Radiographic Technique Reports are complete. The reports were reviewed and are acceptable.

Reshots on B8-1-M(1) have been completed as follows: A3-4, C4-5, E0-1, E1-2, E6-7. A preliminary review of the film to verify film quality was completed and it is acceptable. The film is being interpreted and the reports will be completed.

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Reviewed the weld maps and completed verbal authorizations to proceed on the following:

-Casting B1-1-M(5) G29416 was reviewed. It is acceptable. This repair will be completed in accordance with WPS04-0120FB. This is a "major repair" in accordance with that procedure and post weld heat treatment is required. Verbal authorization to proceed lot no. B243-006-09

-Casting B4-1-M(7) G29422 was reviewed. It is acceptable. This repair will be completed in accordance with WPS04-0120FA. Verbal authorization to proceed lot no. B243-007-09

-Casting B1-1-M(2) G29416 was reviewed. It is acceptable. This repair will be completed in accordance with WPS04-0120FA. Verbal authorization to proceed lot no. B243-008-09

-Casting B7-1-F(1) G29429 was reviewed. It is acceptable. This repair will be completed in accordance with WPS04-0120FB. This is a "major repair" in accordance with that procedure and post weld heat treatment is required. Verbal authorization to proceed lot no. B243-010-09

-Casting B5-1-M(1) G29424 was reviewed. It is acceptable. This repair will be completed in accordance with WPS04-0120FA. Verbal authorization to proceed lot no. B243-009-09

Item	Description	WBS	Dwg No.	Status
1	B14-CBB G29447-1			



Summary of Conversations:

Relevant conversations are documented above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

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Inspected By: Riegler,Randy

Quality Assurance Inspector

Reviewed By: Lanz,Joe

QA Reviewer